

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000118**Date Inspected:** 02-Apr-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 900**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, California**CWI Name:** Bernard Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) Test**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Robert Cuellar is present at the Ironworkers Apprenticeship Training Facility as requested by American Bridge/ Fluor for the continuing purpose of witnessing Procedure Qualification Record tests. The following items have been observed,

1) In addition to the Certified Welding Inspector and the welder being present, ABF Welding Superintendent Mr. Tommy Gibson is also present during the attempt of procedure qualification record (PQR) testing.

2) Today's observations are a continuance of procedure qualification record test attempt for PQR test identified as ABF-PQR-002-1. This is the third attempt of this one inch thick PQR test, which originally commenced on Monday 03-26-2007.

3) Caltrans QA Inspector observed two (2) flux cored arc welding (FCAW) passes applied to the PQR test plate assembly on this date. Both of the FCAW filler passes have been observed as such poor quality that the ABF welder attempted to completely remove them by method of grinding. These FCAW filler passes that have been removed by method of grinding contained visual discrepancies consisting of non-uniform weld profiles, overlap and excessive reinforcement. The welder was observed grinding these weld passes to a bright flush condition prior to applying subsequent weld passes.

After the completion of the two FCAW filler passes applied to the PQR test plate, the Quality Control Inspector of Inspection Services, Inc, Mr. Bernard Docena elected to reject this PQR test plate assembly. Mr. Bernard voiced and documented within his Welding Report that this PQR test plate assembly is rejected for the third time because of the welder's inability to produce a sound weld.

Mr. Bernard Docena presented the Caltrans QA Inspector with a copy of his Welding Report, which captures welding activities for dates 03-27-2007 through today 04-02-2007.

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Mr. Tommy Gibson terminated the witnessing of PQR tests for this project at 0900.

For specific welding parameter values recorded during this procedure qualification record test see the Caltrans TL-6032 generated for this date. Digital pictures that support today's observations are included within the TL-6032.

Summary of Conversations:

1) Mr. Tommy Gibson voiced that PQR testing would resume on Tuesday 04-03-2007. 2) Mr. Tommy Gibson also stated that Smith Emery would be taking over Quality Control Inspection Services commencing on Tuesday 04-03-2007.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Cuellar,Robert	Quality Assurance Inspector
Reviewed By:	Smith,Ryan	QA Reviewer
